

Work Order ID 66830

Monday, February 28, 2011 11:40:20 AM



Page 1

Item ID: D3199-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 2/28/2011 Start Qty: 36.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 36.00



Customer:

Reference:

Approvals: Process Plan:

Date: 1/02/08 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3199	C

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: EProg Rev: E

Deburr if required

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66830

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Page 2

Item ID: D3199-1

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Start Date: 2/28/2011 Start Qty: 36.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 36.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

counted

X51

S1103/03

130



Small Fab

Small Fab

Small Fab

Memo

0.00

SB 1103/04

50

+6

Pto >

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1103/04

counted

X50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-1 PAR #: Fault Category: NCR: Yes No DQA: Date: _____
 Resolution: Disposition: QA: N/C Closed: Date: _____

NCR: 66830		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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11/03/04	130	Tooling was used ~ damaged per ??? 1717 + + +	u 11/03/04	Scrap + destroy + destroy Jig	SD 11/03/04	S 11/03/04	u 11/03/04	S 11/03/04
		u PL unauthorizes people using stuff they no nothing about!		→ make new Jig/ Did new Jig for part new PT number is DT 9723	M 11/03/15	S 11/03/15		

NOTE: Date & initial all entries

Work Order ID 66830

Monday, February 28, 2011 11:40:21 AM



Page 3

Item ID: D3199-1**Revision ID:****Item Name:** Bracket**Start Date:** 2/28/2011 **Start Qty:** 36.00**Required Date:** 3/4/2011 **Req'd Qty:** 36.00**Accept****Setup****Stop****Reference:****Approvals:** Process Plan: _____**Date:** _____**Tooling:** _____**Date:** _____**Run****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

60 . Bl 11-3-11

M 115108 -

Memo

0.00

Powder Coating

START TIME: 11:10
OVEN TEMPERATURE: 320°
FINISH TIME: 11:50

160



QC

QC3- Inspect Part Finish

0.00

50 6 11 11-03-11

Memo

0.00

Quality Control

170



Packaging

Identify as per dwg & Stock Location: JBL0A

0.00

Countless

113/4 (50) 50

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 36.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/3/14

MF

11-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, February 28, 2011 11:40:27 AM

Work Order ID: 66830



Parent Item: D3199-1



Parent Item Name: Bracket

Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
IPP Rev:D As per Rev B 06-11-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	95.5938	0.099	3.751579			

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	95.5938	
115953	21.6	
116437	38.7538	
116623	35.24	



B11-3-2

(51)

16623

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44830
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199	Rev: B C E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>P</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-3-2	Date:	11/03/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	Z

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

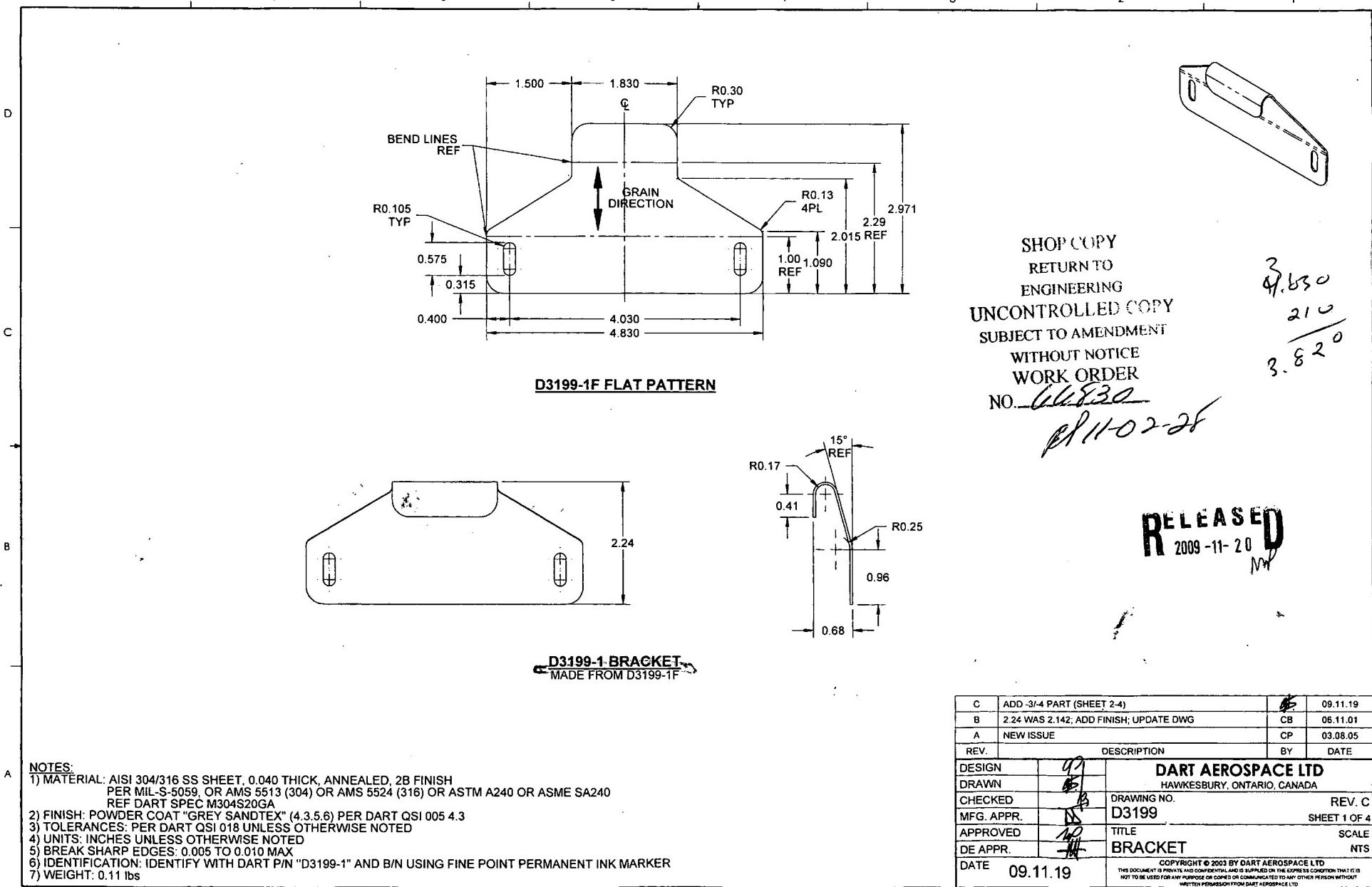
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



C	ADD -3/4 PART (SHEET 2-4)	99	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	55	CB 06.11.01
A	NEW ISSUE	BB	CP 03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	99		
DRAWN	55		
CHECKED	BB		
MFG. APPR.	NS		
APPROVED	MM		
DE APPR.	MM		
DATE	09.11.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3199 REV. C
SHEET 1 OF 4

TITLE: BRACKET NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

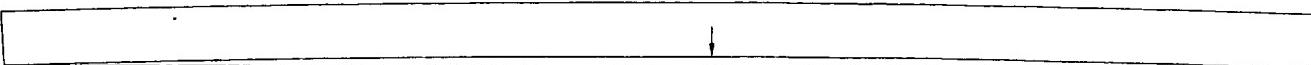
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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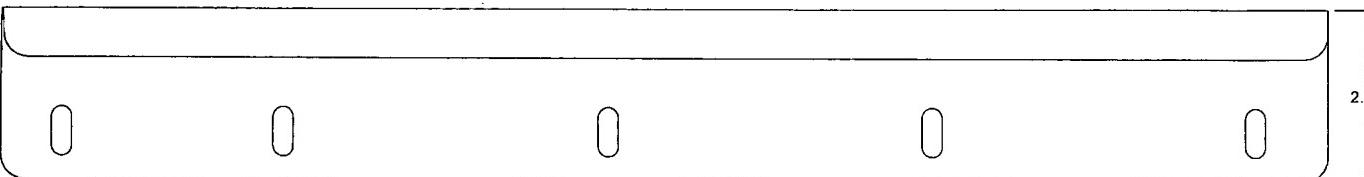
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

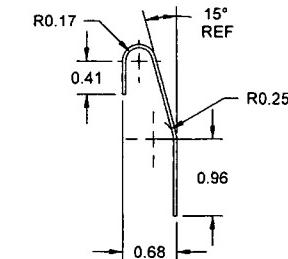
D



C



B



A

△ **D3199-3 BRACKET**
MADE FROM D3199-3F

wb 66830

RELEASED
2009-11-20
MF

NOTES:

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.55 lbs

8 7 6 5 4 3 2 1

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3199 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

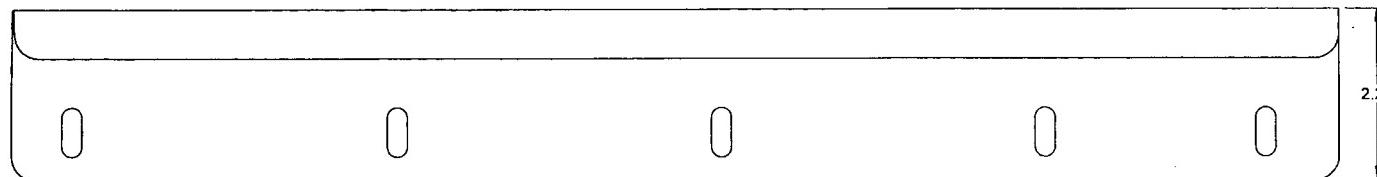
D



0.14

C

C



2.24

B

B

△ D3199-4 BRACKET
MADE FROM D3199-3F

010 06 830

RELEASED
2009-11-20
m

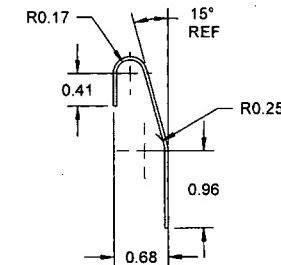
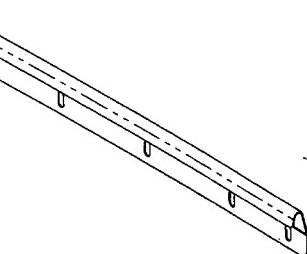
A

A

NOTES:

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.55 lbs

8 7 6 5 4 3 2 1



DESIGN	<i>BB</i>	DART AEROSPACE LTD
DRAWN	<i>BB</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO. REV. C
MFG. APPR.	<i>DS</i>	D3199 SHEET 3 OF 4
APPROVED	<i>MM</i>	TITLE SCALE
DE APPR.	<i>MM</i>	BRACKET NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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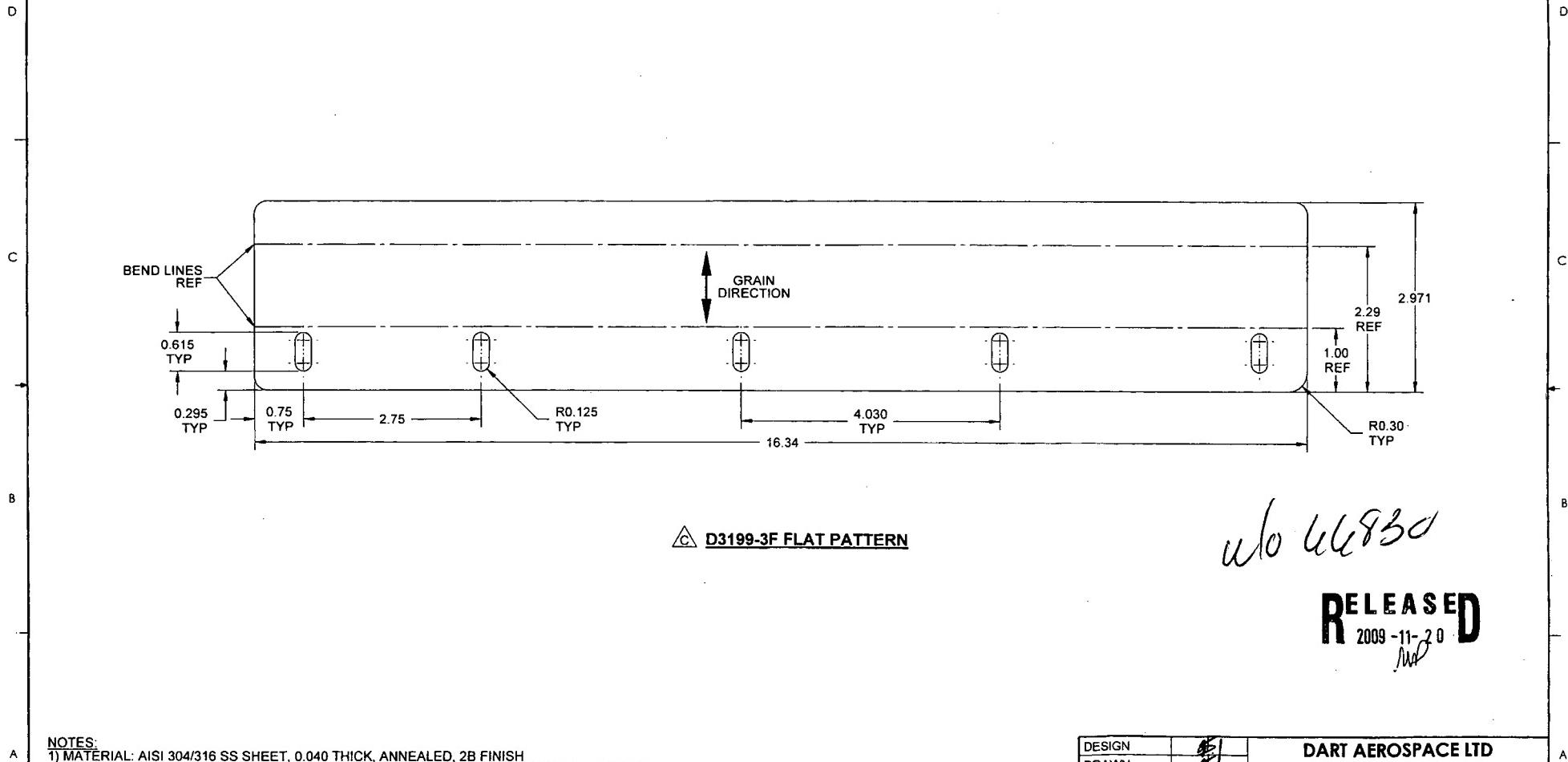
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



△ D3199-3F FLAT PATTERN

RELEASED
2009-11-20
MJ

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.55 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>B</i>	DRAWING NO.	
MFG. APPR.	<i>N</i>	D3199	REV. C
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	BRACKET	NTS
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